

Work Order ID 160817

Thursday, May 04, 2017 2:59:22 PM

160817

Page 1

Item ID: PB67-43001-257

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Inner Tube

Start Date: 5/10/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/16/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

DAS

MAY 05 2017

Approvals: Process Plan:

21

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

100

Small Fab

Small Fab

Memo

0.89

Small Fab

1- cut to length as per dwg

2- deburr

7

MAY 23 2017

DAS

19

9-89

110

110

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.14

Quality Control

7

DAS

38

9-89

JUN 05 2017

120

120

Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

DAS

38

9-89

1.64

Conventional Milling Machine

1- drill hole as per dwg

2- deburr

7

MAY 23 2017

DAS

13

9-89

perch:

110- issue P/O to meler. P/O: 36405 machine as per dwg.

120- need read & inspect attached c/c to W/O

7x8017-530

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo <i>N/A</i> <i>JAS 38 9-89</i>	0.00 0.14							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>WA3</i> Memo LOCATION: WA003	0.00 0.07				<i>7</i>	<i>JUN 05 2017</i>	<i>DAS 24 9-89</i>	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.70					<i>17/6/17</i>	<i>JUN 05 2017</i>	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, May 04, 2017 2:59:22 PM

Page 1

Work Order ID: 160817

160817

Parent Item: PB67-43001-257

PR67-43001-257

Parent Item Name: Inner Tube

Start Date: 5/10/2017

Required Date: 5/16/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.250W.125		Purchased	No			100	f	26.8460	3.46	25.49474			DAS 19 2-89
M6061T6T1 250W 125												MAY 23 2017	
ALUM. RD TUBING 1.250 x.125W													

Location

Loc Qty

Loc Code

MAT

26.846

x3

m132577

12.002

x3

m135249

14.844

x1m137451

10,928571

10,928571

3,6428571

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

INSPECTION SHEET

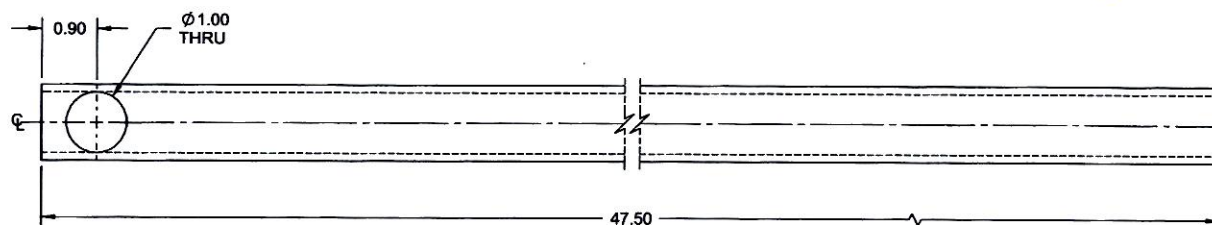
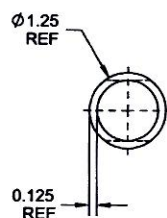
DAS
38
9-89

JUN 05 2017

Engineering Approval:
(If necessary)

9	11
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 160817 MC5
 1205-05



B67-43001-257 INNER TUBE

RELEASED
 2009-09-24
 MP

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
 PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
 AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
 REF. DART SPEC. M6061T6T1.250W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.02 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 23 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR009-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-257 REV. C TITLE INNER TUBE SCALE NTS DATE 09.02.27 COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN	AS			
CHECKED	JW			
MFG. APPR.	JW			
APPROVED	JW			
DE APPR.	N/A			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36405**

Purchase Order Date 5/23/2017

PO Print Date 5/23/2017

Page Number 2 of 5

Order From :
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

3	160817	PB67-43001-257 INNER TUBE	6/7/2017	7.00	\$0.00	\$0.00
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Yes
6/7/2017

8017-530

MACHINE AS PER DWG PB67-43001-257
MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541, M13524, M132577 TUBING ALREADY CUT TO LENGHT

Line Total: \$0.00

4	160829	PB67-43001-247 INNER TUBE	6/7/2017	6.00	\$0.00	\$0.00
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Yes
6/7/2017

MACHINE AS PER DWG PB67-43001-247
MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541

Line Total: \$0.00

5	160833	PB67-43001-255 INNER TUBE	6/7/2017	7.00	\$0.00	\$0.00
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Yes
6/7/2017

MACHINE AS PER DWG PB67-43001-255
MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541

Note:

5/23/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21703
Date: May 29, 2017
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36405	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: May 29, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5159-3 Seat Rib, as per drawing D5159-3 Rev. A	Each	6		6
PB67-43001-127 Handle Arm, as per drawing PB67-43001-127	Each	5	5	0
PB67-43001-257 Inner Tube, as per drawing PB67-43001-257	Each	7	7	
PB67-43001-247 Inner Tube, as per drawing PB67-43001-247	Each	6	6	
PB67-43001-255 Inner Tube, as per drawing PB67-43001-255	Each	7	7	
PB67-43001-259 Inner Tube, as per drawing PB67-43001-259	Each	7	7	
PB67-43001-285 Upper Tube, as per drawing PB67-43001-285	Each	5		5
PB67-43001-197 Outer Tube, as per drawing PB67-43001-197	Each	7		7
PB67-43001-229 Outer Tube, as per drawing PB67-43001-229	Each	7		7
PB67-43001-235 Outer Tube, as per drawing PB67-43001-235	Each	7		7
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SP 17-5-30-</u>	Thank you for your order!			



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

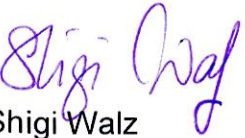
same

Quantity	Part Number	Part Name	Material & Batch #	P.O. Number
✓ 7	PB67-43001-257	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541, M13524, M132577	36405
6	PB67-43001-247	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405
7	PB67-43001-255	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405
7	PB67-43001-259	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 29, 2017